

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011748**Date Inspected:** 01-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Xu Xian Ping			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	OBG Sub- Assembly		

Summary of Items Observed:

On this day Caltrans OSM Quality Assurance (QA) Inspector Daniel Barrentine was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China.

Non-Destructive Testing:

Ultrasonic Testing (UT) pursuant to NDT Inspection Notification Sheet(s) (Document No. 005160):

This QA inspector performed Ultrasonic Testing (UT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

1. DP-3004-001; weld 026
2. DP-3043-001; weld 026

This QA Inspector observed the following work in progress:

Flux Cored Arc Welding (FCAW) of 21TR3-002; Weld 005. Welder is identified as 215397. ZPMC Quality Control (QC) is identified as Tian Lei. Weld Procedure Specification (WPS) is identified as

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WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS.

Flux Cored Arc Welding (FCAW) of 21TR3-003; Weld 003. Welder is identified as 054460. ZPMC Quality Control (QC) is identified as Tian Lei. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS.

Flux Cored Arc Welding (FCAW) of 20TR1-012; Weld 003. Welder is identified as 201912. ZPMC Quality Control (QC) is identified as Tian Lei. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS.

Flux Cored Arc Welding (FCAW) of 20TR2-005; Weld 015. Welder is identified as 044824. ZPMC Quality Control (QC) is identified as Guo Yuan Ting. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS.

Flux Cored Arc Welding (FCAW) of 20TR2-012; Weld 015. Welder is identified as 204338 and 214945. ZPMC Quality Control (QC) is identified as Guo Yuan Ting. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS.

Flux Cored Arc Welding (FCAW) of 20TR2-009; Weld 009. Welder is identified as 050988. ZPMC Quality Control (QC) is identified as Guo Yuan Ting. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS.

Flux Cored Arc Welding (FCAW) of 20TR2-014; Weld 009. Welder is identified as 206623. ZPMC Quality Control (QC) is identified as Guo Yuan Ting. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS.

Flux Cored Arc Welding (FCAW) of 21TR3-004; Weld 007. Welder is identified as 054460. ZPMC Quality Control (QC) is identified as Guo Yuan Ting. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS.

Flux Cored Arc Welding (FCAW) of 20TR2-005; Weld 011. Welder is identified as 044824. ZPMC Quality Control (QC) is identified as Guo Yuan Ting. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS.

Flux Cored Arc Welding (FCAW) pursuant to Weld Repair Report #B-WR10334 (for ZPMC UT Reject) of 11TR3-010; Weld 014. Welder is identified as 053609. ZPMC Quality Control (QC) is identified as Zhong Dian Xing. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-2G(2F)-Repair-1. Welding appears to conform to the requirements of the WPS and WRR used.

Flux Cored Arc Welding (FCAW) pursuant to Weld Repair Report #B-10487 (for ZPMC UT Reject) of 11TR1-026; Weld 014. Welder is identified as 201215. ZPMC Quality Control (QC) is identified as Zhong Dian Xing. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-1G(1F)-Repair-1. Welding appears to conform to the requirements of the WPS and WRR used.

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Flux Cored Arc Welding (FCAW) pursuant to Weld Repair Report #B-WR10607 (for ZPMC UT Reject) of 10TR2-013; Weld 014. Welder is identified as 067079. ZPMC Quality Control (QC) is identified as Zhong Dian Xing. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-2G(2F)-Repair-1. Welding appears to conform to the requirements of the WPS and WRR used.

Flux Cored Arc Welding (FCAW) pursuant to Weld Repair Report #B-WR10246 (for ZPMC UT Reject) of 10TR2-022; Weld 010. Welder is identified as 201912. ZPMC Quality Control (QC) is identified as Zhong Dian Xing. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-2G(2F)-Repair-1. Welding appears to conform to the requirements of the WPS and WRR used.

Flux Cored Arc Welding (FCAW) pursuant to Weld Repair Report #B-WR10510 (for ZPMC UT Reject) of 11TR2-004; Weld 014. Welder is identified as 201912. ZPMC Quality Control (QC) is identified as Zhong Dian Xing. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-1G(1F)-Repair-1. Welding appears to conform to the requirements of the WPS and WRR used.

Summary of Conversations:

No Relevant Conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Barrentine, Daniel	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
